5/39

DART AEROSPACE LTD	Work Order:	24376
Description: Wearplate	Part Number:	D3319-1
Dwg: D3319 Rev. B page 1	Qty:	4
05.10.03 HJ		Page 1 of 1

Step	Location	Procedure	By	Date	Qty
1	DC	Issue Traveler	HJ	05.10.03	4
2	PG	Issue P/O: 20085410 **Email or Ship DXF file to vendor** Laser Cut flat pattern per Dwg D3319 Possible Supplier: Industrial Laser **Material release note is required**	4	05.09.23	4
3	RG	Receive and inspect for transit damage **Ensure material release note is attached**	dl	05/09/28	4
4	QC6	Inspect dimensions as per inspection template D3319-1T1			
5	GA	Deburr if necessary			
6	GB	Form using DT8326 & DT8261 as per Dwg D3319 Dwg Rev:			
7	GB	Form flat on press using DT8776 block Dwg Rev:			
8	QC6	Inspect dimensions as per Dwg D3319			
9	WS	Weld hard surface using D3319-1T2 as per QSI 004 and Dwg D3319 Dwg Rev: _____ Qty / Part Number / Description / Batch A/R / N/A / 7560 Hardcoat Rod			
10	QC9	Inspect weld			
11	FP	Powder Coat Grey Sandtex (Ref: 4.3.5.6) as per QSI 005 4.3			
12	QC3	Inspect Powder Coat			
13	ST	Identify on inside surface using a permanent fine point marker with the following: **TCCA-PDA, Dart Aerospace Ltd.** **P/N: D3319-1, B/N: BXXXXX** **For Product Eligibility see ~~PDA01-18~~ PDA05-18** and Stock			
14	AC	Cost / part: 51.52	SLC	05-10-20	
15	DC	Close W/O Inspect Level 21			

PTO

RH 05.09.27

Rev	Date	Change	Revised By	Approved
A	05.05.12	New issue	KJ/JLM	

PRELIMINARY ISSUE

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Mfg / Design Mgr	Approval QC Inspector

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Design Mgr	Approval QC Inspector
			Initial Design Mgr	Action Description Design Mgr	Sign & Date			
05-10-19	4	Parts made to Rev:A instead of Rev:B., holes are too narrow		Scrap ~~& replace~~ ~~to Rev:B~~.	05-10-19	05-10-19		05-10-19

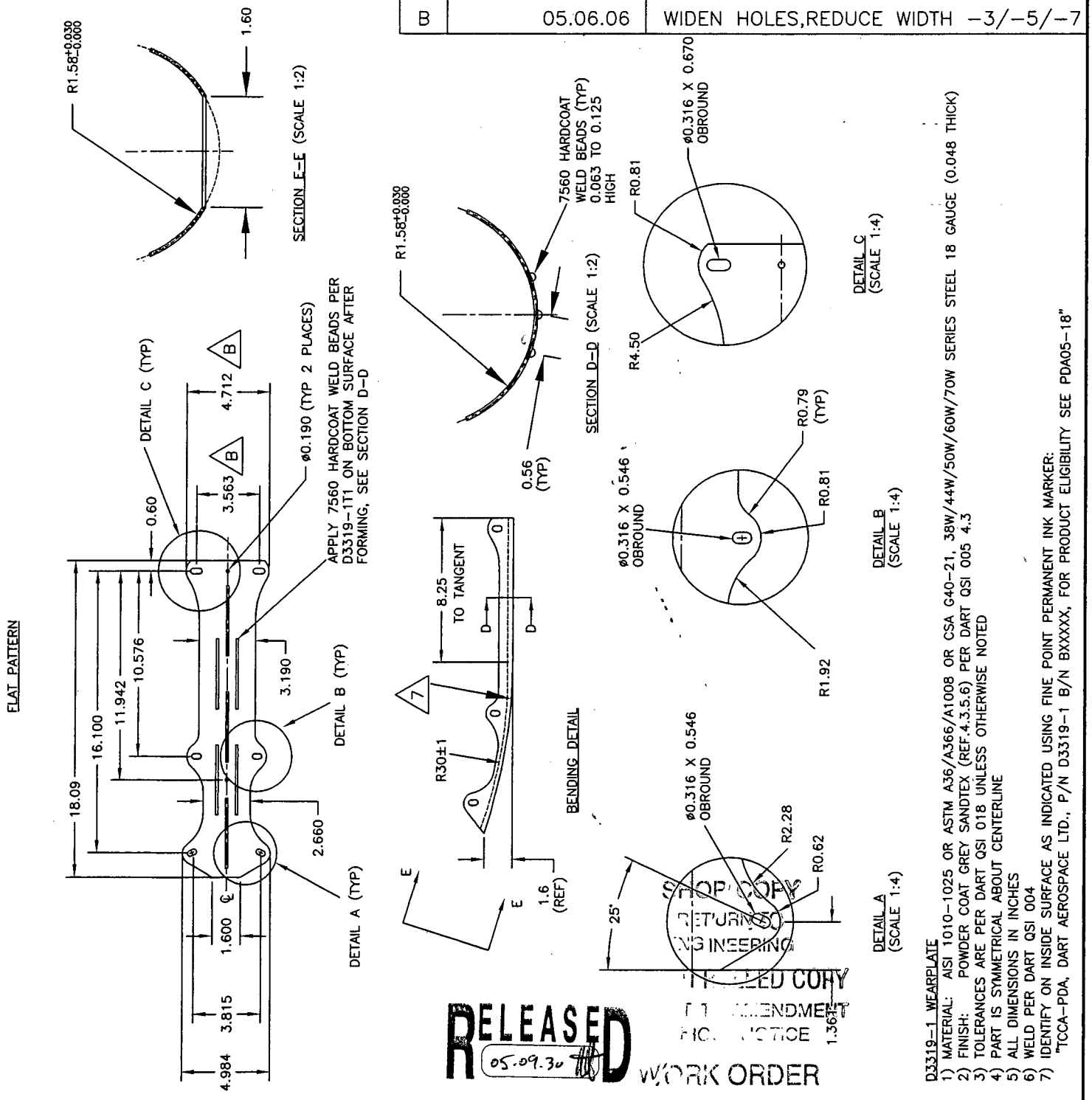
Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ **Date:** _____

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
PH	PH		
CHECKED	APPROVED	DRAWING NO.	REV. B
		D3319	SHEET 1 OF 5
DATE		TITLE	SCALE
05.06.06		WEARPLATE	1:8

A	04.09.24	NEW ISSUE
B	05.06.06	WIDEN HOLES, REDUCE WIDTH −3/−5/−7



RELEASED
05-09-30
WORK ORDER
NO. 24376

D3319-1 WEARPLATE
1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21, 38W/44W/50W/60W/70W SERIES STEEL 18 GAUGE (0.048 THICK)
2) FINISH: POWDER COAT GREY SANDTEX (REF.4.3.5.6) PER DART QSI 005 4.3
3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
4) PART IS SYMMETRICAL ABOUT CENTERLINE
5) ALL DIMENSIONS IN INCHES
6) WELD PER DART QSI 004
7) IDENTIFY ON INSIDE SURFACE AS INDICATED USING FINE POINT PERMANENT INK MARKER:
"TCCA-PDA, DART AEROSPACE LTD., P/N D3319-1 B/N BXXXXX, FOR PRODUCT ELIGIBILITY SEE PDA05-18"

Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Sep 30, 2005
09:27 am

Work Order No	: 0024376		
Project Name	: D3319-1	Department Code	:
Project For	: WK539	Burden Flags	: NNNNNNN
Work Order Type	: Main	WO Status	: Open
Main WO Number	:	Invoice State	: Not Invoiced
House Part Number	: D3319-1	Invoice Date	:
Description	: Wearplate	Invoice Number	:
Manufactured	: Yes	Invoice Amount	: 0.00
Amount Req'd	: 4		
Amount Done	: 0	Order Entry No	:
Start Date	: 09-30-05	OE Value	: 0.00
Est Finish Date	: 09-30-05		
Act Finish Date	:	Est Mark Up	: 0.000%
Drawings Reqd	: No	Actual Mark Up	: 0.000%
Ok for Approval	:		
Approval Rec'd	:	$0 Posted to Finished Goods	

	Estimated	Actual	Var. %	Posted	To Post
Material Cost :	0.00	0.00	0.00	0.00	0.00
Engineering Hours :	0.00	0.00	0.00		
Engineering Cost :	0.00	0.00	0.00	0.00	0.00
Production Hours :	0.00	0.00	0.00		
Production Cost :	0.00	0.00	0.00	0.00	0.00
Packaging Hours :	0.00	0.00	0.00		
Packaging Cost :	0.00	0.00	0.00	0.00	0.00
OverHead Hours :	0.00	0.00	0.00		
OverHead Cost :	0.00	0.00	0.00	0.00	0.00
CNC Hours :	0.00	0.00	0.00		
CNC :	0.00	0.00	0.00	0.00	0.00
Misc. Hours :	0.00	0.00	0.00		
Misc. :	0.00	0.00	0.00	0.00	0.00
Burden :	0.00	0.00	0.00		
Total Cost :	0.00	0.00	0.00		
Mark up :	0.000	0.000			
Selling Cost :	0.00	0.00			

	Estimated	Actual
Labour Hrs/Amount Done :	0.00	0.00
Profits/(Loss) :	0.00	0.00

NEW ZEALAND STEEL

New Zealand Steel Limited
Glenbrook, South Auckland
Postal: Private Bag 92121, Auckland, New Zealand
Telephones: (09) 375 8999 / 375 8111 Auckland
(09) 235 8069 / 235 3535 Waiuku
Fax: (09) 375 8958

TEST CERTIFICATE

Ref: 5005/21329

CUSTOMER	Wilkinson P41007DI002	SPECIFICATION	ASTMA1008 CS Type A
CUSTOMER O/N	90-21N-288	PRODUCT	CRA WIDE COIL
MILL O/N	453665	DIMENSIONS	0.033" × 48" × Coil

CERTIFICATE No TC107796
PAGE 1 of 1
DATE 31 March 2005

PACK NUMBER	HEAT No	CHEMICAL COMPOSITION PERCENT															MECHANICAL TESTS (TEST SPECIFICATION - ASTMA370)						
		C	Si	Mn	P	S	Cu	Ni	Cr	Mo	V	Nb	Ti	Al	B	N2	CE( )	BEND	YIELD	T.S.	%ELONG	HARDNESS	r	LENGTH
		x100			x1000										x10000		x100	180°			G.L.=	HRB	( )	(feet)
R9-455932-00	640077	5	TR	20	10	16	14	17	18	1	6	1	1					Good				41		2621
R9-455933-00	640077	5	TR	20	10	16	14	17	18	1	6	1	1					Good				41		2723
R9-455934-00	640077	5	TR	20	10	16	14	17	18	1	6	1	1					Good				50		2546
R9-455935-00	640077	5	TR	20	10	16	14	17	18	1	6	1	1					Good				50		2789

YIELD (A)=0.2% PROOF STRESS (B)=LOWER YIELD STRESS	GAUGE LENGTH (G.L.) (A)=200mm (C)=80mm (E)=2" (B)=50mm (D)=5.65 ? So (F)=8"	PLASTIC STRAIN RATIO (r) (A)=r0 (C)=r45 (B)=r90 (D)=(r0+r90+2r45) / 4	IMPACT TEST (A)=10mm x 10mm (C)=5mm x 5mm (B)=7.5mm x 10mm (D)=2.5mm x 10mm (E)=5mm x 10mm	CARBON EQUIVALENT VALUE (CE) (A)=C+Mn/6 (B)=C+Mn/6+(Cr+V+Mo)/5+(Cu+Ni)/15 (C)=C+Mn/6+Si/24 (D)=

WE HEREBY CERTIFY THAT THE MATERIAL DESCRIBED HEREIN HAS BEEN TESTED AND INSPECTED WITH SATISFACTORY RESULTS IN ACCORDANCE WITH THE REQUIREMENTS OF THE ABOVE SPECIFICATION

APPROVED Satish Misra
QC METALLURGIST

20 GA CRMs